

Date: Friday, 22/08/2008 2:02:42 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 41603	
Estimate Number : 12487	
P.O. Number :	Part Number : D35021
This Issue : 22/08/2008 S.O. No. :	Drawing Number : D3502 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 35783	Material :
Written By :	Due Date : 25/09/2008 Qty: 38 Um: Each
Checked & Approved By : <u>JLD 08.8.22</u>	
Comment : Est Rev:A New Issue 06-07-06 JLM Est Rev:B Add tooling hole 07-03-28	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X04000	6061-T6 Bar 1.00 x 4.00
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Comment: Qty.: 0.3035 f(s)/Unit Total : 6.0690 f(s)

6061-T6 Bar 1.0" x 4.0"

batch: M107221 mmc 08/08/31

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 3.475" long

mmc 08/08/31

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA649 Rev: B & Dwg D3502 Rev: B

2-Deburr per dwg D3502

N.A 08/09/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 08/09/10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

26 08/09/11 (38)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 2:02:43 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 41603

Part Number: D35021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill as per Dwg D3502.

FF 08/10/02

38

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-10-02 (38)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:50
320
8:20

M-1 08/10/03

(38X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-03

(38X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

105 8/10/6

(38X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08

Job Completion



08/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

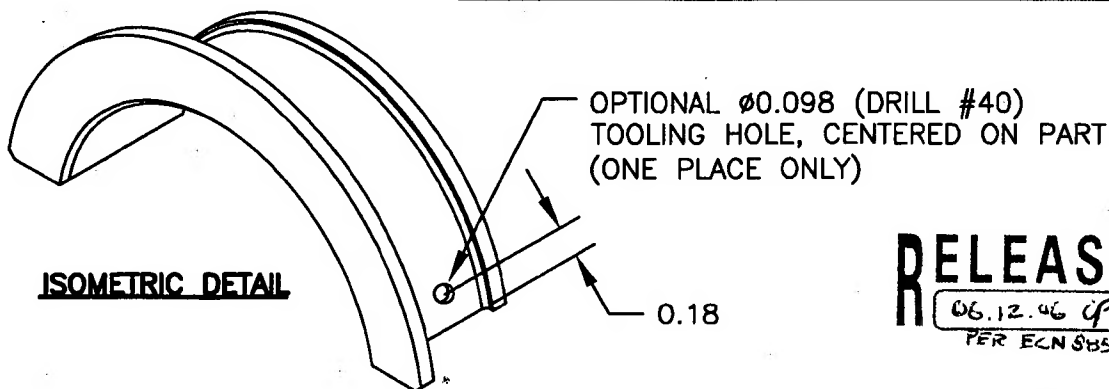
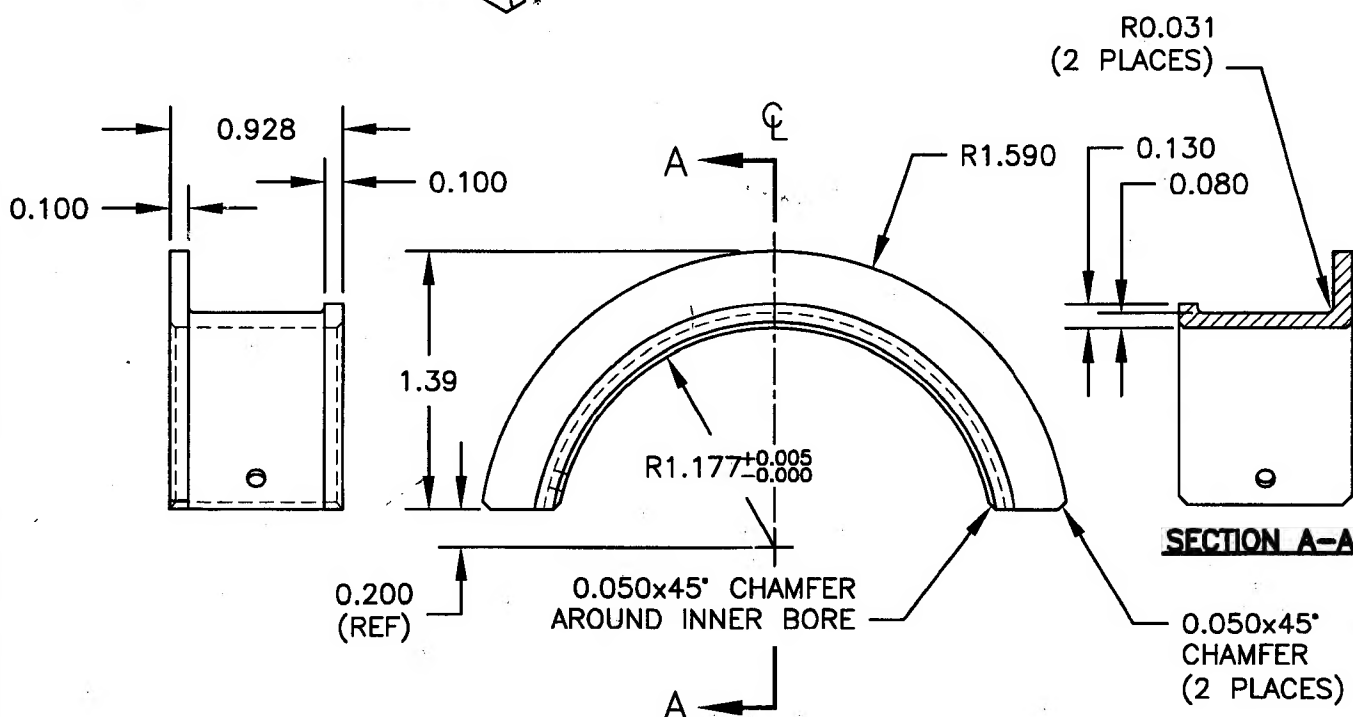
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN qp	DRAWN BY qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31	TITLE SUPPORT		SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	

**RELEASED**
06.12.06 qp
PER ECN 885**D3502-1 SUPPORT**

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41603

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